

Work Order ID 61629

Monday, August 30, 2010 2:26:21 PM

BLUE



Page 1

Item ID: D206-642-412BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH, Blue

Start Date: 9/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mt*

Date: 10-8-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-412 CHG006

5/10/09/28

Hof BG 10-9-22

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/9/23

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/10/09/28

(H)

361456

Work Order ID 61629

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Item ID: D206-642-412BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH, Blue

Start Date: 9/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-412 Location: _____ PPP Rev: <u>E</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/9/2009

10/09/28/09

MF
10-9-28

Picklist Print

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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-41A Bolt		Purchased	No				Each	260.0000	8	8			
-----------------	--	-----------	----	--	--	--	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST354	260	
112431	1	
114382	9	
114522	50	
114941	200	

AN4-6A Bolt		Purchased	No				Each	1,423.000	12	12			
----------------	--	-----------	----	--	--	--	------	-----------	----	----	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST356	1423	
112933	96	
113149	24	
114523	2	
114615	1	
114941	500	
115108	300	
115457	500	

AN4C5A BOLT		Purchased	No				Each	500.0000	1	1			
----------------	--	-----------	----	--	--	--	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST346	500	
110552	9	
112243	491	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-11A

Purchased

No

Each

146.0000

8

.8



Bolt



10/9/23SL

Location

Loc Qty

Loc Code

ST337

21

112314

1

115016

20

ST338

125

AN5-12A

Purchased

No

Each

102.0000

4

.4



Bolt



10/9/23SL

Location

Loc Qty

Loc Code

ST338

102

112314

102

AN5-13A

Purchased

No

Each

60.0000

4

.4



Bolt



10/9/23SL

Location

Loc Qty

Loc Code

ST338

60

114615

20

115316

40

AN960C416

NAS1149C0463
R

Purchased

No

Each

105.0000

1

.1



washer



M112314 10/9/23SL

Location

Loc Qty

Loc Code

ST346

105

100993

105

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No
Washer

Each 6.0000 8

10/9/23SD M115622 SD

Location Loc Qty Loc Code

ST 6
107715 6

AN960JD416 NAS1149D0463J Purchased No
Washer

Each 0.0000 24

M115622 10/9/23SD

AN960JD516 NAS1149D0563J Purchased No
Washer

Each 34.0000 8

M114742 10/9/23SD

Location Loc Qty Loc Code

ST 34
103694 18
107534 12
109287 4

D206-642-441 Manufactured No
Replacement Skidtube

Each 6.0000 1

B61456 10/9/23SD

Location Loc Qty Loc Code

FG081 6
24739 1
30265 1
30266 1
30940 1
31066 1
35469 1

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

D206-648-013

Manufactured No

Each

2.0000

1

1



GHW Modification

CHG 10/2



BA 538 10/9/23 SP

Location

Loc Qty

Loc Code

FG120

2

42315

1

47600

1

att: blue LUG

D2652

Manufactured No

Each

156.0000

16

16



Bushing



10/9/23 SP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST020

112

61197

112

D2712

Manufactured No

Each

553.0000

10

10



Set Screw



10/9/23 SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST022

503

50415

3

61331

500

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

D2932-2

Manufactured No

Each

6.0000

1

1



Saddle RH Out, 206



10/9/23sf

Location

Loc Qty

Loc Code

ST421

2

41440

1

53329

1

ST428

4

60253

4

att: blue

D2933-2

Manufactured No

Each

2.0000

1

1



Saddle RH In, 206



10/9/23sf

Location

Loc Qty

Loc Code

ST428

2

41129

1

53330

1

att: blue

D2934

Manufactured No

Each

44.0000

2

2



Saddle Spacer



10/9/23sf

Location

Loc Qty

Loc Code

FG

6

31929

6

ST031

38

59641

38

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

D2935-
Saddle Spacer

Manufactured No

Each 30.0000

2 2
10/9/23

Location Loc Qty Loc Code

ST028 30
59642 30

Manufactured No

Each 1.0000

1 1
10/9/23

D2938-2
Saddle RH Out, 206

Location Loc Qty Loc Code

ST421 1
53332 1

Manufactured No

Each 2.0000

1 1
10/9/23

att: blue
D2939-2
Saddle RH In, 206

Location Loc Qty Loc Code

ST428A 2
53334 1
58268 1

Manufactured No

Each 25.0000

1 1
10/9/23

att: blue
D3407-043
Tow Ring

Location Loc Qty Loc Code

ST464 25
42211 1
43308 1
50387 15
53351 8

att: blue

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

Each

42.0000

1

1



Ring



10/9/23SP

Location

Loc Qty

Loc Code

ST473

42

51586

1

53446

19

61322

22

att: blue

D3456-1

Manufactured No

Each

35.0000

1

1



Washer



10/9/23SP

Location

Loc Qty

Loc Code

ST058

35

54692

35

D3457-1

Manufactured No

Each

37.0000

2

2



Washer



10/9/23SP

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

27

45913

1

52981

26

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 61629

Parent Item: D206-642-412BL

Parent Item Name: Skidtube RH, Blue

Start Date: 9/13/2010

Required Date: 9/28/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

2,174.000

8

8



Nut



10/19/23sf

Location

Loc Qty

Loc Code

ST300

2174

114523

115

114718

59

114784

2000

8

MS21042L4

Purchased

No

Each

2,535.000

12

12



Nut



10/19/23sf

Location

Loc Qty

Loc Code

ST300

2535

112314

12

113422

68

114523

28

114718

16

114784

491

115108

1920

12

MS21043-4

Purchased

No

Each

929.0000

1

1



Nut



10/19/23sf

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

889

112492

25

113069

8

114181

29

114348

27

114523

500

114784

300

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.6 206L/L-1/L-3/L-4 HIGH GEAR SKIDTUBES

Item	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	Part Number	Description
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-7	SKIDTUBE ASSEMBLY
2A			22			D2651-1	* PLUG ⁽¹⁾
2B			22			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-13A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)
22B			1	1		D3536-15	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)
24B			1	1		D3536-37	GASKET
26A			60	60		MS27039C1-08	SCREW
26B			60	60		AN960JD10L	WASHER
26C			60			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	LUG ASSEMBLY (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-7 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N
Date: 09.09.09